



### **Abstract of the Disclosure**

Method for operating rolling stands of a tandem cold rolling mill, including a pair of work rolls and a pair of backup rolls for four-high rolling stands and, in addition, a pair of intermediate rolls for six-high rolling stands. At least the work rolls and the intermediate rolls interact with axial shifting devices. The following technologies are used together within the multiple-stand tandem cold rolling mill:

CVC/CVC<sup>plus</sup> technology with CVC roll contours of higher order, wherein each work or intermediate roll has a barrel lengthened by the amount of the shifting stroke;

pair-cross technology, wherein each work or intermediate roll can be swiveled parallel to the plane of the strip; and

strip edge-oriented shifting of the work or intermediate rolls. The work or intermediate rolls are each symmetrically axially shifted from the neutral shift position by equal amounts symmetrically to the center of the stand.